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Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Aug 09, 2005  
11:26 am

Work Order No : 0024000  
Project Name : pB67-43001-213 ✓  
Project For : WK538  
Work Order Type : Main  
Main WO Number :  
House Part Number : pB67-43001-213  
Description : Flanged Hook  
Manufactured : Yes  
Amount Req'd : 38  
Amount Done : 30  
Start Date : 08-09-05  
Est Finish Date :  
Act Finish Date :  
Drawings Reqd : No  
Ok for Approval :  
Approval Rec'd :  
Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DART AEROSPACE LTD	Work Order:	24000
Description: Flanged Hook	Part Number:	B67-43001-213
Inspection Dwg: B67-43001 Rev: B		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	JML
Date:	05/08/15

Audited by:	<u>PC</u>
Date:	05.08.15

<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	05.07.11	New Issue	KJ/JLM	

H:\FORMS\Quality Assurance\approved QA\FAI revD

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_

PAR #: \_\_\_\_\_

Fault Category: \_\_\_\_\_

NCR: Yes

No

DQA:

Date: 05/08/17

NOTE: Date &amp; initial all entries

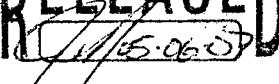
QA: N/C Closed: \_\_\_\_\_

Date: \_\_\_\_\_

5/38

DART AEROSPACE LTD	Work Order:	24000
Description: Flanged Hook	Part Number:	B67-43001-213
Dwg: B67-43001 Rev. B page 17	Qty:	38 40
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	TY	05.08.12	38
2	MV	Cut blanks: 2.00" x 1.00" x 2.750" long Material: 6061-T6 Bar (QQ-A-225/8 or QQ-A-200/8) (M6061T6B1.000x02.000) <b>Identify for B67-43001-213</b> Batch: <u>A17365</u> <u>m</u> 05/08/14 40			
3	MV	Machine as per Folio FA531 and Dwg B67-43001 <b>Identify as B67-43001-213</b> Dwg Rev <u>B</u> Folio Rev <u>B</u>	TY	05/08/15	40
4	QC2	Inspect parts as they come off the CNC machine	TY	05/08/15	40
5	QC8	Second check	E	05.08.15	40
6	MV	Deburr	TY	05/08/15	40
7	ST	Identify and Stock	TY	05/08/16	40
8	AC	Cost / part: <u>7.42</u>	SAC	05.08.17	40
9	DC	Close W/O <u>11.90</u> Inspect Level 21	(1)	05/08/17	40
Rev	Date	Change	Revised By	Approved	
A	05.06.08	New issue	KJ/JLM		

RELEASED  
  
 05.06.08

DART AEROSPACE LTD	Work Order:	400 46
Description: FLANGED HOOK	Part Number:	PB67-43001-2B
Inspection Dwg: B6743001 Rev: B1		Page 1 of 1

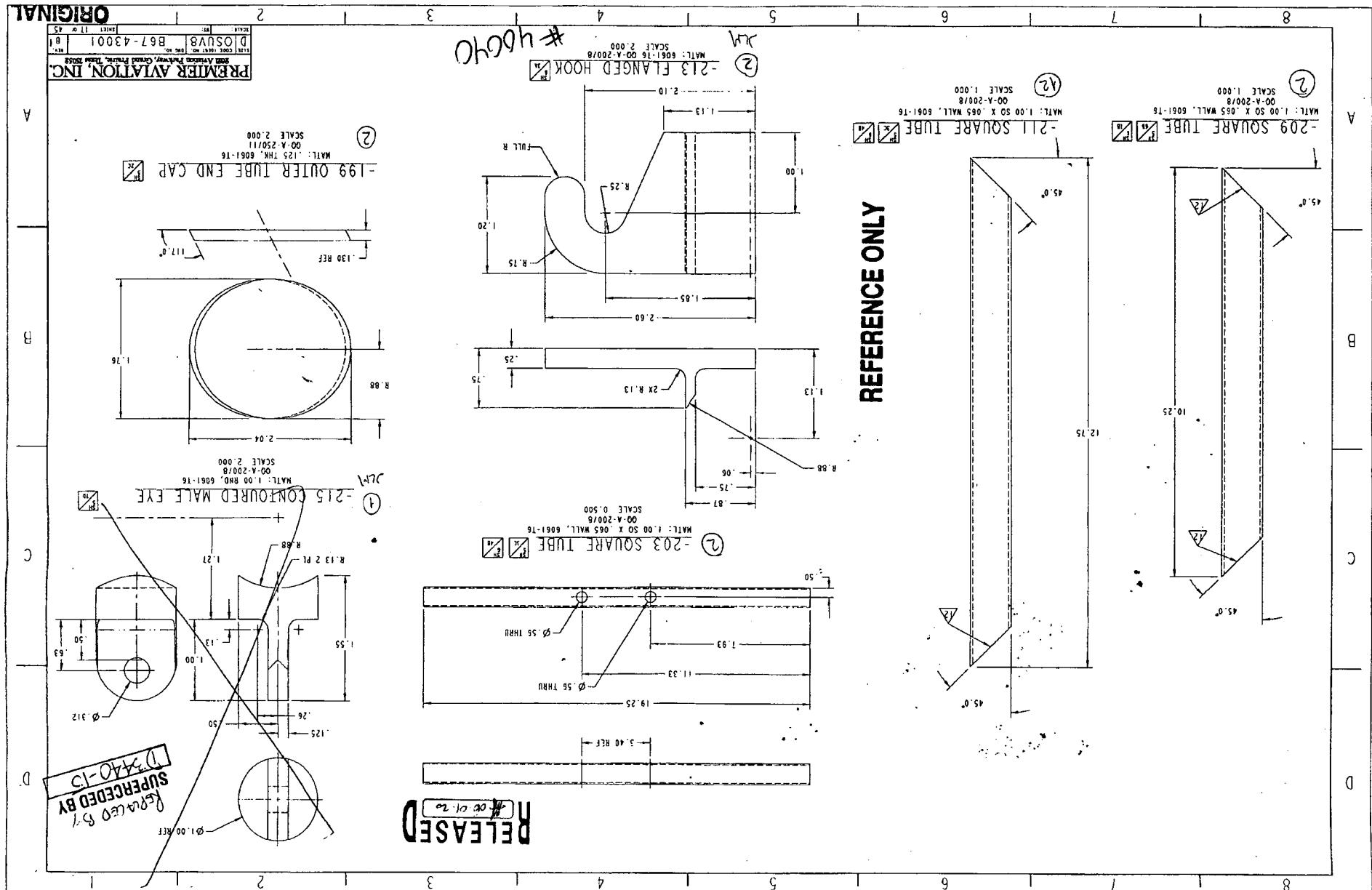
## **FIRST ARTICLE INSPECTION CHECKLIST**

## X First Article      Prototype

Measured by:	<i>JNL</i>	Audited by:	<i>DSR</i>	Prototype Approval:	<i>MP</i>
Date:	08/06/27	Date:	08/06/27	Date:	<i>MP</i>

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A		New Issue	KJ/JLM	





W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 24/06/2008 1:32:53 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLANGED HOOK

Job Number: 40040

Part Number: PB6743001213

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *Part E.*

*mf 08 - 07 - 09*

7.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

*mf 08-07-09*

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 24/06/2008 1:32:53 PM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: FLANGED HOOK		
Job Number	: 40040					
Estimate Number	: 12066					
P.O. Number	:			Part Number	: PB6743001213	
This Issue	: 24/06/2008		S.O. No.	: PAGE17		
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type	: MACHINED PARTS		
Previous Run	:			Drawing Revision	: B1	
Written By	:			Material	:	
Checked & Approved By	: <u>JMF</u> 08-06-24			Due Date	: 01/07/2008	
Comment	: Est. A05.06.08 New issue KJ/JLM			Qty:	10	Um: Each

## Additional Product

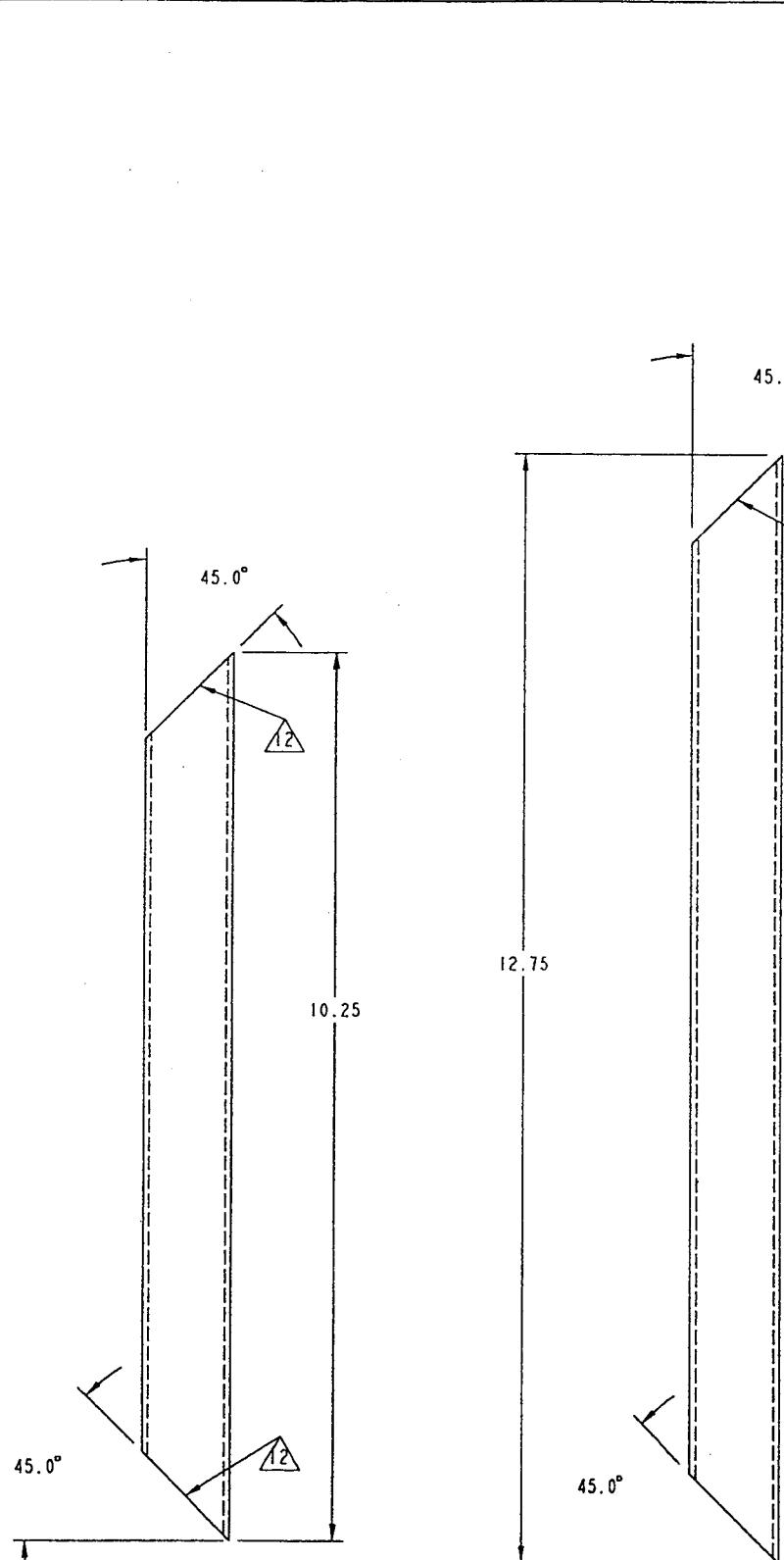
Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B1000X02000	6061-T6 Bar 1.0" x 2.0"	
		Comment: Qty.: 0.2516 f(s)/Unit Total: 2.5158 f(s) 6061-T6 Bar 1.0" x 2.0" Material: 6061-T6 Bar (QQ-A-225/8 or QQ-A-200/8) M6061T6B1.000x02.000 Identify for B67-43001-213 Batch: <u>M104187</u>	
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blanks: 2.00" x 1.00" x 2.750" long	
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA531 and Dwg B67-43001 Identify as B67-43001-213 Dwg Rev <u>B1</u> Folio Rev <u>A1</u>	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	

8 | 7 | 6 | 5 | 4 | 3 | 2 |

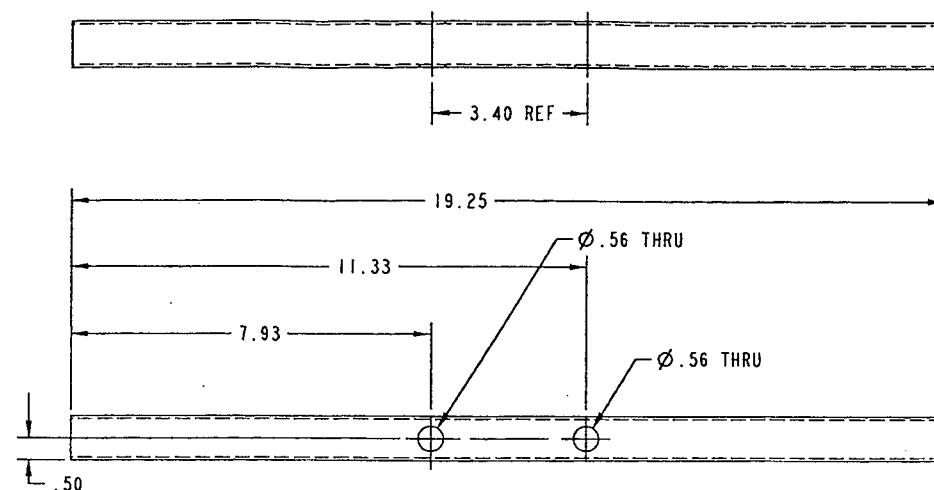
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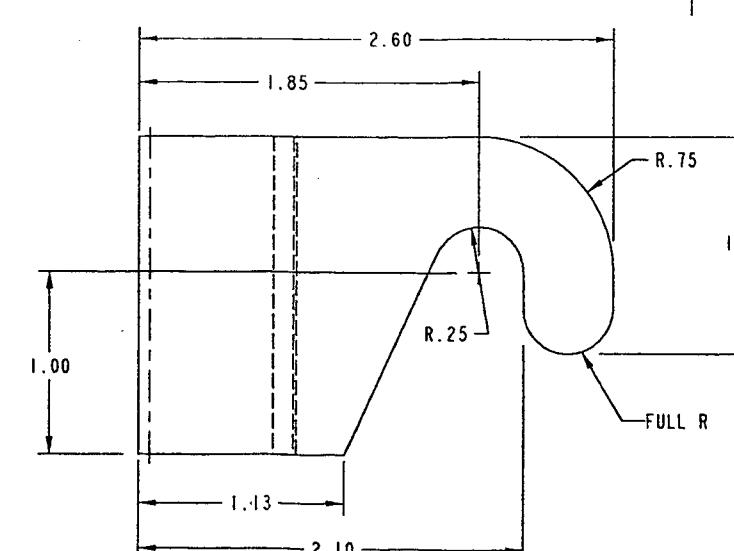
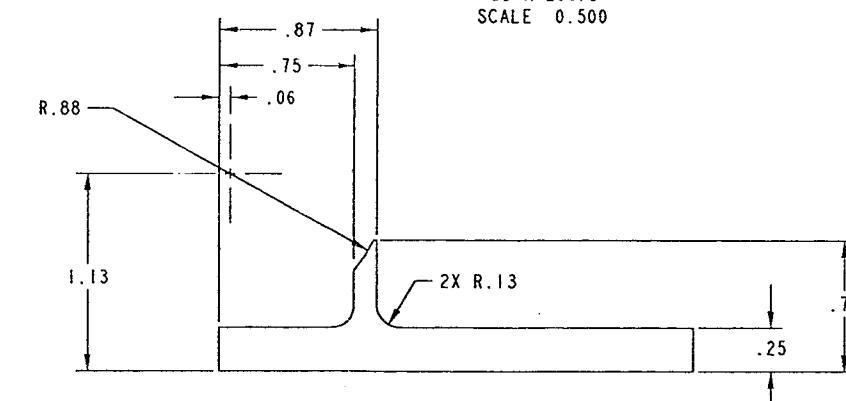
-209 SQUARE TUBE SH 5/6 SH 6/8  
MATL: 1.00 SQ X .065 WALL, 6061-T6  
QQ-A-200/8  
SCALE 1.000  
(2)

-211 SQUARE TUBE SH 5/3C SH 6/4B  
MATL: 1.00 SQ X .065 WALL, 6061-T6  
QQ-A-200/8  
SCALE 1.000  
(2)

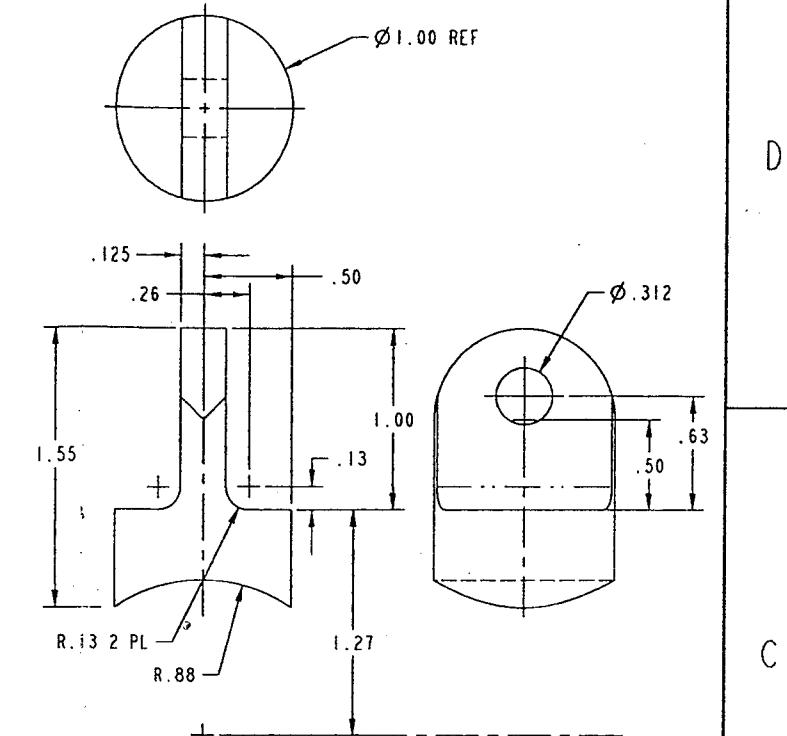
-213 FLANGED HOOK SH 6/3A  
MATL: 6061-T6 QQ-A-200/8  
SCALE 2.000  
JLM



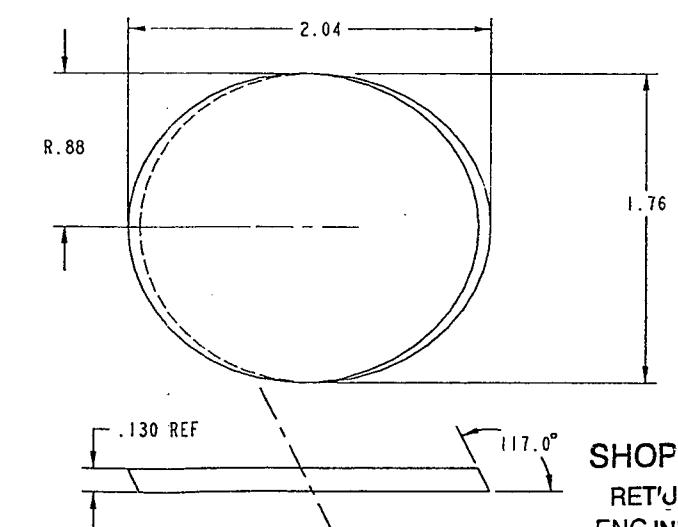
(2) -203 SQUARE TUBE SH 5/3C SH 6/4B  
MATL: 1.00 SQ X .065 WALL, 6061-T6  
QQ-A-200/8  
SCALE 0.500



(2) -199 OUTER TUBE END CAP SH 5/3C  
MATL: .125 THK, 6061-T6  
QQ-A-250/11  
SCALE 2.000  
JLM



(1) -215 CONTOURED MALE EYE SH 5/7D  
MATL: 1.00 RND, 6061-T6  
QQ-A-200/8  
SCALE 2.000



SHOP COPY  
RETURN TO  
ENGINEERING

UNCONTROLLED COPY

-199 OUTER TUBE END CAP SH 5/3C  
MATL: .125 THK, 6061-T6  
QQ-A-250/11  
SCALE 2.000  
(2)

WORK ORDER  
NO. 24000

PREMIER AVIATION, INC.  
2621 Aviation Parkway, Grand Prairie, Texas 75052  
SHEET CODE IDENT NO. D OSUV8 DNG NO. B67-43001 REV. B  
SCALE: WT: SHEET 17 of 45

ORIGINAL

8 | 7 | 6 | 5 | 4 | 3 | 2 |